

Date: Monday, 27/04/2009 9:09:46 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE
 Job Number : 47490
 Estimate Number : 13420
 P.O. Number :
 This Issue : 27/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : PB6743001207
 Drawing Number : B6743001 P.5/ P.16
 Project Number : N/A
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : B1
 Previous Run : 43199 Material :
 Due Date : 04/05/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : MF-09-04-27
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6TS1000W120

6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.9469 f(s)/Unit Total: 1.9469 f(s)

6061T6 SQ TUBE 1.00X.120

batch: ~~4740885~~ M109928

EP 09/04/28
 (Pb)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.090" chamfer on both ends of tube

3- deburr

EP 09/04/28
 (H)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/04/28
 (H)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

HA 09/04/28

5.0

QC5

INSPECT WORK TO CURRENT STEP

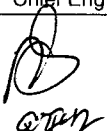
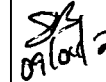




Comment: INSPECT WORK TO CURRENT STEP

HA 09/04/28
 (H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-207 PAR #: N/A Fault Category: Prod / FAB ASSY ^{made Smo?} NCR: Yes No DQA: D Date: 09/04/29
 Resolution: U Disposition: USE AS ^{re-work} QA: N/C Closed: D Date: 09/04/30

NCR: <u>47490</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/28	# 2.0	employee pulled wrong mat. Pulled and cut too length a piece of 1" Round tubing instead of 1" Square tubing		write Batch # of wrong on wrong mat.	 09/04/28	S		S
				Pull correct mat and cut too length.	 09/04/28			
		EC Lack of attention		As Per Dwg. M109928				S 09/04/28

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 9:09:46 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 47490

Part Number: PB6743001207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing
batch: 844988

PC09-04-29

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Square Cap
batch: 847504

PC09-04-29

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

PC09-04-29

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush
2- deburr

PC09-04-29

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5026469 @

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5096469 @

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: ST437

PC09-04-29 @

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

MF 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

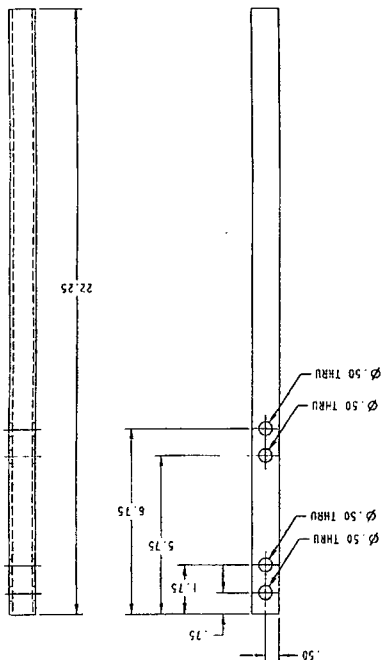
ORIGINAL

PREMIER AVIATION, INC.		3000 Aviation Parkway, Grand Prairie, Texas 75052	
STATE: TX		COUNTY: TARRANT	
CITY: GRAND PRAIRIE		ZIP: 75052	
FAX: 972-261-1645		TEL: 972-261-1645	

①
-207 SQUARE TUBE
MATERIAL: 1.00 SQ X 1.25 WALL, 6061-T6
CO-A-200/8
SCALE 0.500

① -205 OUTER TUBE
MAIL: 1.75 OD X .065 WALL, 6001-16
WM-1-780/6
SCALE 0.250

① -197 OUTER TUBE
MATT: 1.75 OD X .665 WALL, 6061-T6
WM-1-700/6
SCALE 0.250



RELEASED
JUL 26 4 22

5
 -201 SQUARE TUBE
 17.5 15.5 13.5 11.5 9.5 7.5 5.5 3.5 1.5
 17.5 15.5 13.5 11.5 9.5 7.5 5.5 3.5 1.5
 00-4-200/8
 SCALIT 0.500
 MAT: 1 00 SG X 0.65 WAI3. 6661-16

